

Date: Tuesday, 4/4/2006 1:27:11 PM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : WEB
Job Number : 26490
Estimate Number : 10498
P.O. Number : NIA Part Number : D2739
This Issue : 4/4/2006 S.O. No. : NIA Drawing Number : D2739 REV C
Prsht Rev. : NC Project Number : N/A
First Issue : NIA Type : LANDING GEAR Drawing Revision : C
Previous Run : 26385 Material : NIA
Written By : See Comment Below Due Date : 4/17/2006 Qty: 4 Um: Each
Checked & Approved By : 06.04.04
Comment : Est Rev: 02.11.28 Reformat KJ
Est Rev: D 06-03-21 As Per Rev C JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D26005108 Extrusion 'I Beam' thin



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Extrusion 'I Beam' thin

Pick:

Qty Part Number Description Batch

1 D2600-5 Web 06-05-08 4

2.0 LANDING GEAR 1 LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Cut D2600-5 to length as per Dwg D2739. 06-05-08

2-Drill pilot holes in web using drilling Jig DT8162 as per Dwg D2739 06 05 08 4

3-Use uni-bit to open holes to finish size as per Dwg D2739. 06 05 08

4-Bevel Fwd ends (1" max) of extrusion and Deburr holes and ends. 06-05-08

5-Deburr 06-05-08

6-Use a red or black lead-free paint pen to write the part number and batch number in the middle of each

web.

3.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

06-05-08

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 2/25/11
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Seq. #:

Machine Or Operation:

Description :

4.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

IT 06-09-08

4

5.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

BF 06-05-08

4

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: Cell

IT 06-05-08

4

7.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

SP 06/05/09 (4)

Job Completion



12 Dec 05-09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

